

Patent Claims:

1. Motor/pump unit, especially for slip-controlled motor vehicle brake systems, including an accommodating member (3) for hydraulically active components, an internal gear pump arranged in a bore (7) of the accommodating member (3) and comprising pump components such as a pinion/internal gear combination arranged between two housing parts (20, 21), wherein the pump components form a pre-assembled unit, and including a motor (2) for driving the internal gear pump,  
c h a r a c t e r i z e d in that the housing parts (20, 21) can be arranged preliminarily by at least one securing element in such a fashion that the final alignment of the housing parts (20, 21) relative to each other takes place when the unit is inserted into the accommodating member (3).
2. Motor/pump unit as claimed in claim 1,  
c h a r a c t e r i z e d in that the at least one securing element connects the housing parts (20, 21) with a relative clearance to each other, and in that a bore (7) is provided in the accommodating member (3) for the alignment of the housing parts (20, 21) in a radial direction.
3. Motor/pump unit as claimed in claim 2,  
c h a r a c t e r i z e d in that a first housing part (20) is fixed on the accommodating member (3) so as to be undisplaceable in an axial direction and a radial

direction, and in that the first housing part (20) is provided to lock the pump components in the accommodating member (3).

4. Motor/pump unit as claimed in any one of the preceding claims 1 to 3,  
c h a r a c t e r i z e d in that a pin (38, 46) with a first end (39) is provided as a securing element which is press fitted into a bore of one of the housing parts (20, 21), and in that the pin (38, 36) includes a second end (41) with a stop (42) for securing another housing part (20, 21) in position.
5. Motor/pump unit as claimed in claim 4,  
c h a r a c t e r i z e d in that the pin (38, 46) is arranged in parallel to a pump shaft (12).
6. Motor/pump unit as claimed in any one of claims 1 to 4,  
c h a r a c t e r i z e d in that the pin (38, 46) includes a cylindrical portion (43), which extends through a bore (44) of the stop-sided housing part (21), and in that the bore (44) has a diameter that is larger compared to the cylindrical portion (43), and in that the diameter is smaller compared to the stop (42).
7. Motor/pump unit as claimed in claim 4,  
c h a r a c t e r i z e d in that a maximum of three pins (38) are provided, and in that the pins (38) are arranged at a regular angle ( $\alpha$ ) relative to each other.

8. Motor/pump unit as claimed in any one of the preceding claims,  
c h a r a c t e r i z e d in that the internal gear (16) is supported in a ring (17), in that ring (17) is arranged in an axial direction between the housing parts (20, 21), said ring (17) being pivotable relative to the housing parts (20, 21) about a pivot axis (A) that is arranged in parallel to the pump shaft (12).
9. Motor/pump unit as claimed in any one of the preceding claims,  
c h a r a c t e r i z e d in that a pin (46) is used as pivot axis (A), and in that the pin (46) is supported in bores (47, 48) of the housing parts (20, 21).
10. Motor/pump unit as claimed in any one of the preceding claims,  
c h a r a c t e r i z e d in that a housing part (20) accommodates an end (33) of a spring element (32), and in that another end (35) of the spring element (32) is engaged in a bore (36) of the ring (17).